

Date: Tuesday, 22/07/2008 8:49:18 AM
 User: Melanie Fauteux

Process Sheet

*Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 40693 -2
 Estimate Number : 13479
 P.O. Number :
 This Issue : 22/07/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : LARGE FAB ASSY
 Previous Run :
 Written By :
 Checked & Approved By : MF 08-07-20.
 Comment : Est Rev:A 08-07-18 new issue DD verified by:ec

Drawing Name : ADJUSTABLE ATTACHMENT ARM ASSY
 Part Number : PB674300159
 Drawing Number : B6743001 P.14
 Project Number : N/A
 Drawing Revision : B1
 Material :
 Due Date : 29/07/2008 Qty: 3 Um: Each

split
3

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 PB6743001113 Square Tubing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Square Tubing

batch: B40599 X3 SP 08-07-31 (4X)

2.0 PB6743001119 End Cap Clevis



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

End Cap Clevis

batch: B40016 V SP 08-07-31 (4X)

3.0 PB6743001117 Hook Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Hook Plate

batch: B40015 V SP 08-07-31 (4X)

4.0 PB6743001115 Tube End Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Tube End Plate

batch: B40014 V SP 08-07-31 (4X)

5.0 PB6743001271 Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Doubler

batch: B40058 V SP 08-08-06 (8X)



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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

M6061T6T1750W065

6061T6 RDTUBE 1.750 X 0.65W



Comment: Qty.: 0.1575 f(s)/Unit Total: 0.7875 f(s)

6061T6 RDTUBE 1.750 X 0.65W

batch: M 18188

SP 08-07-31 - 08-08-06

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: 1- to make -105 take M6061T6 tube and fabricate to fit contour of cut

2- Weld -105 to -113 as per dwg and grind weld flush

3- weld 119, -117 and -115 to -113 as per dwg PB67-43001

4- pick two -271 and weld one on each side of tubing but only one need to be trim to fit on -113 as per dwg

PB67-43001

NOT READ THIS BATCH ONLY TO AVOID CRACKING

SP 08-08-01 (4X)

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

D 08-08-01 (4)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/07 (4X)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-L

08/08/08

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1- Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9:15
320 OF
9:45

M-L

08/08/08

12.0

QC3

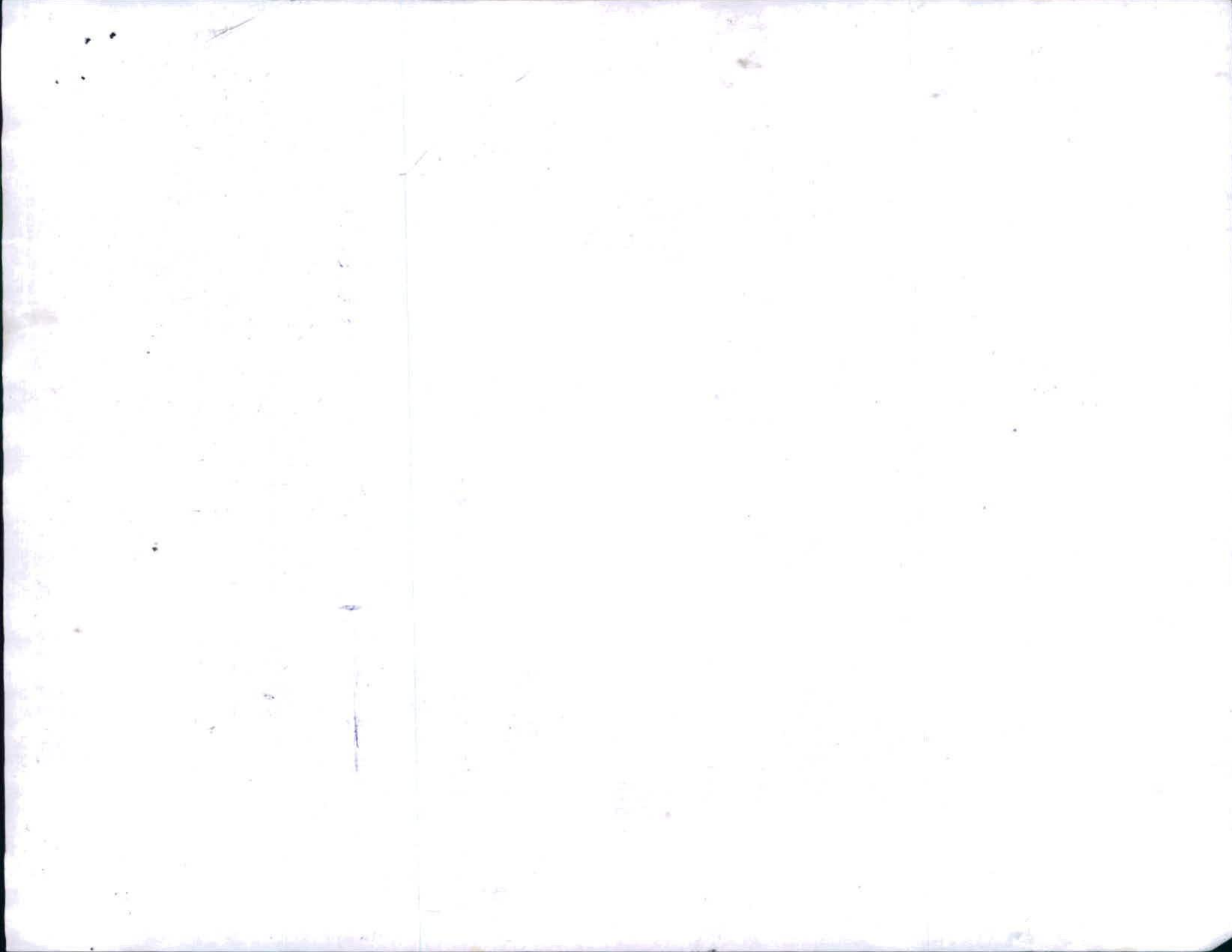
INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-08-08

(4X)



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Part Number: PB674300159

Job Number:



Seq. #:	Machine Or Operation:	Description :
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13.0	PB6743001267	PB67-43001-267
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)
PB67-43001-267
batch: 340095

Handwritten: 08-08-26 3

14.0	PB6743001121	Square Sleeve
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)
Square Sleeve
batch: 340612

Handwritten: 08-08-26 3

15.0	BSP43	RIVET
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Comment: Qty.: 6.0000 Each(s)/Unit Total: 30.0000 Each(s)
RIVET
batch: 17890

Handwritten: 08-08-26 3

16.0	MS17984C413	PIN, QUICK RELEASE
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)
PIN, QUICK RELEASE
batch: 108826

Handwritten: 08-08-26 3

17.0	30345T21	LANYARD
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)
LANYARD
batch: 102812

Handwritten: 08-08-26 3

18.0	MS27039122	SCREW
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)
SCREW
batch: 18057

Handwritten: 08-08-26 3

19.0	MS21042L3	Nut
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)
Nut
batch: 108814

Handwritten: 08-08-26 3

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Part Number: PB674300159

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

NAS1149F0332P

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

WASHER

batch: 18057

08-08-26

3

21.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- take -267 and transfer drill holes in -113 as per dwg PB67-43001

2- deburr and rivet -267 to -113 as per dwg

3- assemble rest of parts as per dwg PB67-43001

08-08-26

3

22.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/08/06 (R3)

23.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Pat 6

08/08/06 (R3)

24.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

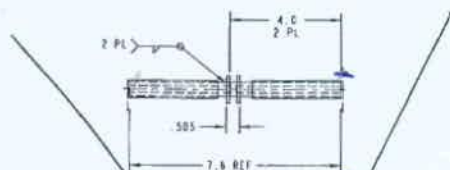
08/08/06

Job Completion



MF- 08-08-26

RELEASED



- 39 ONLY 2 PL
- 41 ONLY 2 PL
- 55 ONLY (SHOWN) 2 PL

8.30 REF

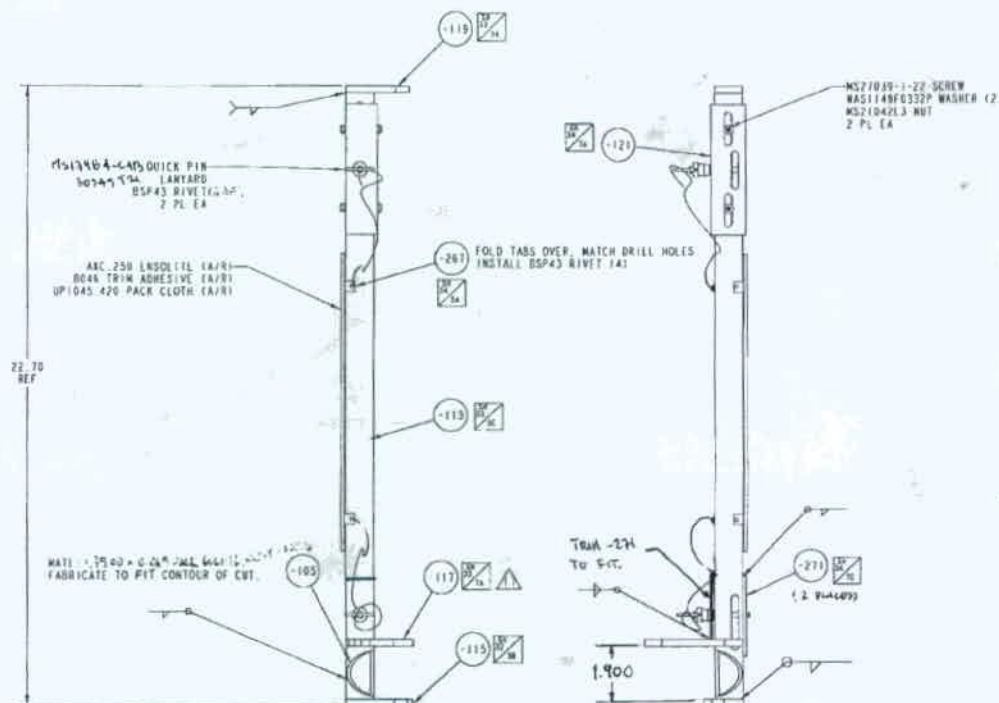
LC 0.500-3-1/4" IL FE
701-88 BLACK CAP
2 PL (1 PL OPP)

- ① -39 HANDLE AND LOCK-DOWN ASSEMBLY (SAME, EXCEPT AS SHOWN)
- ① -41 HANDLE AND LOCK-DOWN ASSEMBLY (SAME, EXCEPT AS SHOWN)
- ② -55 HANDLE AND LOCK-DOWN ASSEMBLY (SHOWN)

SCALE 0.500

SUPERCEDED BY

DISAPPROVED BY 13451-041/-043/-045/-047



- ① -59 ADJUSTABLE ATTACHMENT ARM ASSY

SCALE 0.500

#40693

PREMIER AVIATION, INC.
8800 Aviation Parkway, Grand Prairie, Texas 75050
D105UV8 B67 43001

ORIGINAL

